

Date: Wednesday, 02/04/2008 11:27:14 AM
User: Julie Lecocq

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services			Drawing Name	: HELI ACCESS HANDLE WELDMENT ASS'Y, LH		
Job Number	: 38292						
Estimate Number	: 10946						
P.O. Number	:			Part Number	:	D2480011	
This Issue	: 02/04/2008	S.O. No.	:	Drawing Number	:	D2480 REV A1	
Prsht Rev.	:	NC		Project Number	:	N/A	
First Issue	:	/ /	Type	Drawing Revision	:	A1	
Previous Run	:	38024		Material	:		
Written By	:			Due Date	:	09/04/2008	Qty: 5 Um: Each
Checked & Approved By	:	JD 08.04.08					
Comment	: Est. B1 03.01.09 added Powder Coat						

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	D2478	Lower Arm	
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)	
		Lower Arm	
		Pick:	
	Qty	Part number	Description
	1	D2478	Heli Access Handle <i>B 38/46</i> ✓ <i>08-04-08 SP</i>
2.0	D2479	Upper Arm	
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)	
		Upper Arm	
		Pick:	
	Qty	Part number	Description
	1	D2479	Heli Access Handle <i>B 38 228</i> ✓ <i>08-04-08 SP</i>
3.0	D2481	Lower Mount Plate	
		Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s)	
		Lower Mount Plate	
		Pick:	
	Qty	Part number	Description
	2	D2481	Mounting Plate <i>B 38/47</i> ✓ <i>08-04-08 SP</i>
4.0	D2482	Upper Mount Plate	
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)	
		Upper Mount Plate	
		Pick:	
	Qty	Part number	Description
	1	D2482	Mounting Plate <i>B 38/48</i> ✓ <i>08-04-08 SP</i>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 02/04/2008 11:27:14 AM
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HELI ACCESS HANDLE WELDMENT ASS'Y, LH

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Job Number:



Seq. #: Machine Or Operation:

Description :

5.0 LARGE FAB 1

LARGE FABRICATION RESOURCE 1



M10607Ked.



(5X)

Comment: LARGE FABRICATION RESOURCE 1

Weld as per Template DT 8333 (DT 2480 CJ)

SD 08-04-07

6.0 QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

DD 08-04-07 (5)

7.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SD 08/04/07 (S210)

8.0 POWDER COATING

POWDER COATING



M 107550

(3) 14.

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.2) as per QSI 005 4.3

BL 08-04-07

9.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



S44

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

M- 08/04/07

10.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: PPP 38275

FC 08/04/07 (5)

11.0 QC21

FINAL INSPECTION/W/O RELEASE



08/04/09 JJ

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 08-04-08

W

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

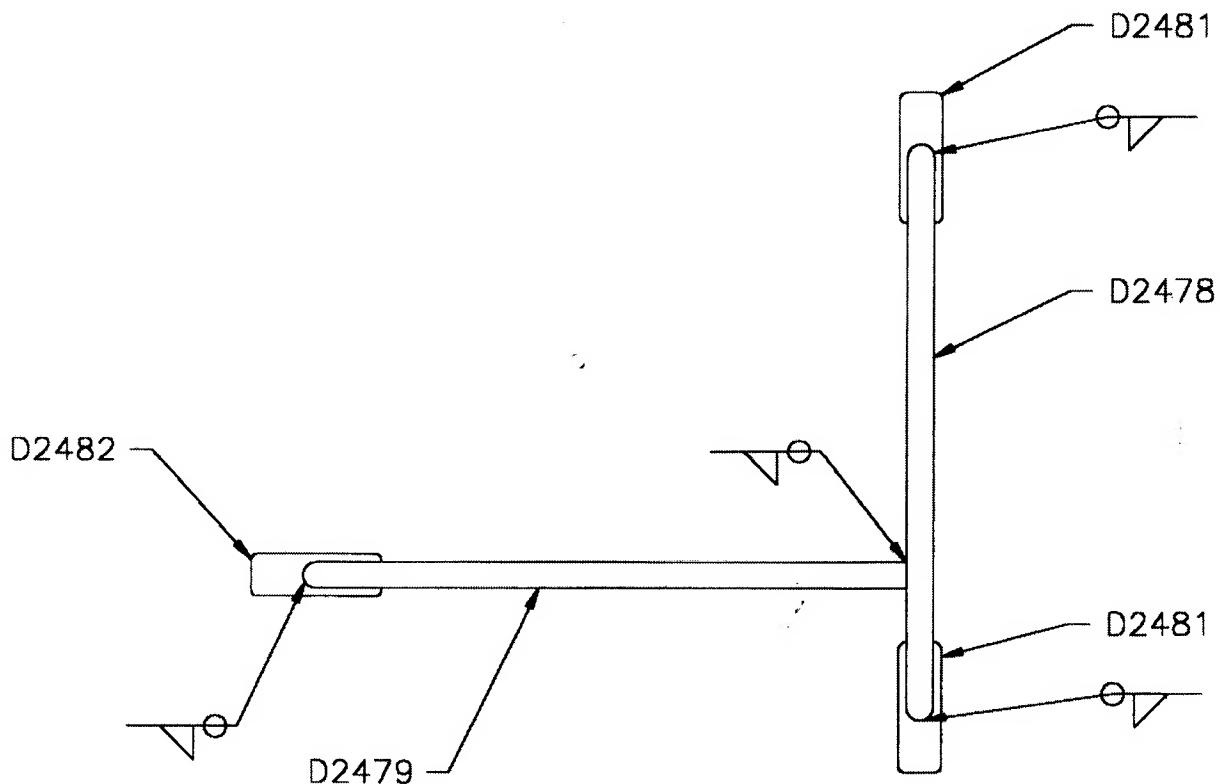
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN B WILLIAMS	DRAWN BY MIKE M	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED <i>Bu</i>	APPROVED <i>Bu</i>	DRAWING NO. D2480	REV. A SHEET 1 OF 1
DATE 96:05:14		TITLE HANDLE WELDMENT ASSEMBLY	SCALE 6:1
A1	<i>10/05/06.23</i>	ADDED POWDER COAT	

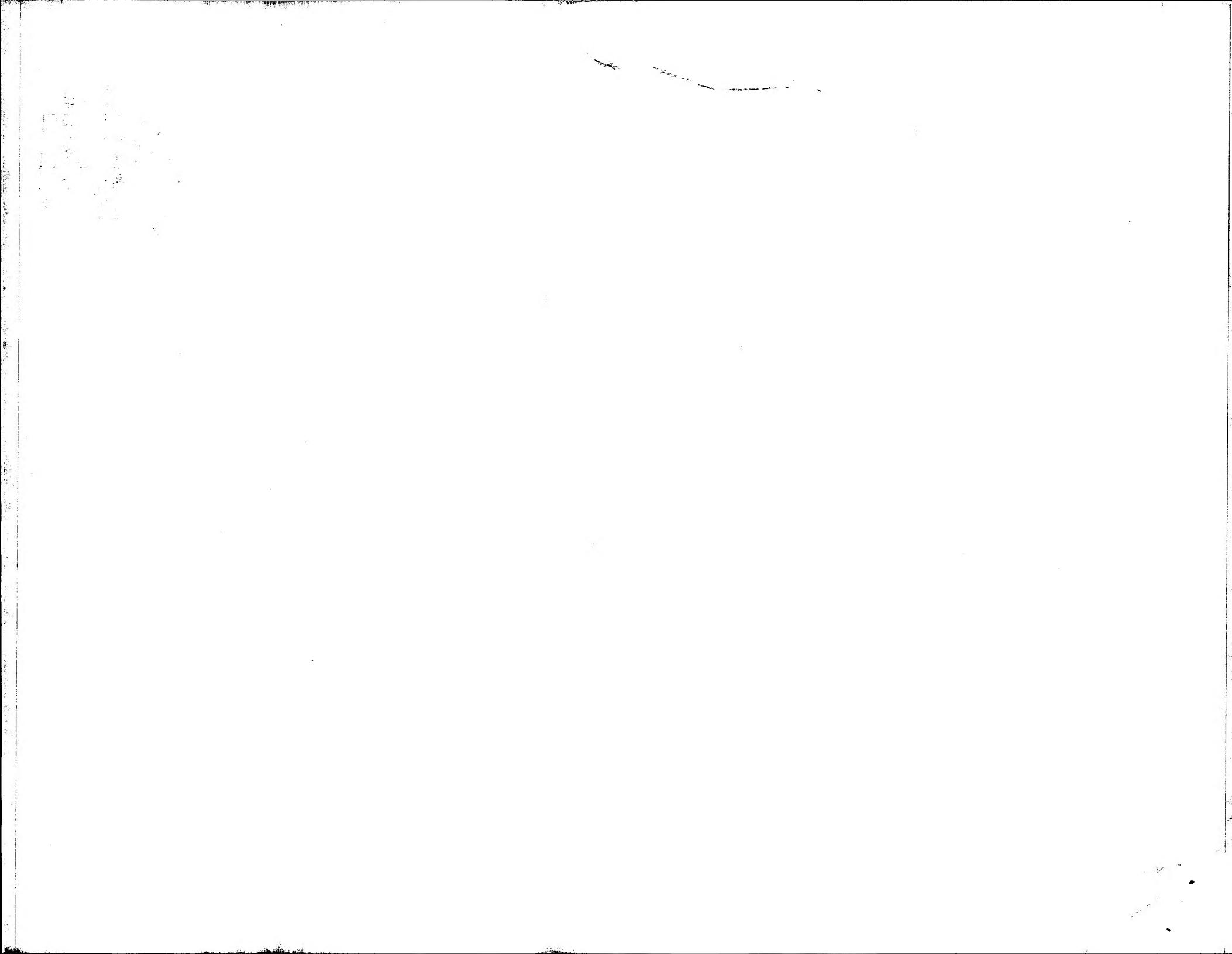
RELEASED
96/10/02 DS


D2480-011 LH SHOWN
D2480-012 RH OPPOSITE

NOTES:

1) WELD PER TEMPLATE DT 2480 WG PER QSI 004
 A1 2) POWDER COAT WHITE GLOSS (REP: 4,3,5,2) AS PER QSI 005

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WITHOUT NOTICE
WORK ORDER
NO. 38292

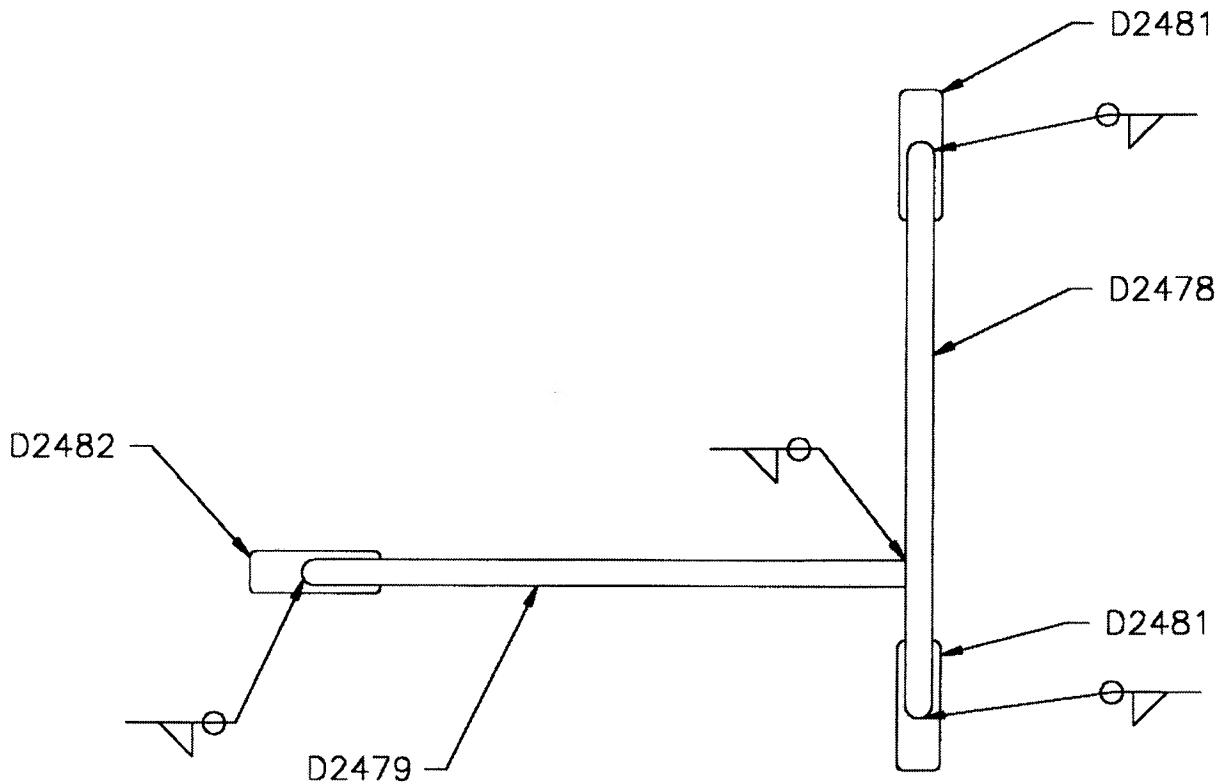




COPY ISSUED
DATE

DESIGN B. WILLIAMS	DRAWN BY MIKE M	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED <i>BW</i>	APPROVED <i>BW</i>	DRAWING NO. D2480	REV. A SHEET 1 OF 1
DATE 96:05:14		TITLE HANDLE WELDMENT ASSEMBLY	SCALE 6:1
		A1 <i>05.06.23</i>	ADDED POWDER COAT

RELEASED
16/10/02 DS



D2480-011 LH SHOWN
D2480-012 RH OPPOSITE

NOTES:

1) WELD PER TEMPLATE DT 2480 WG PER QSI 004
2) POWDER COAT WHITE GLOSS (REF: 4.3.5.2) AS PER QSI 005

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